

Date: Thursday, 27/11/2008 4:02:49 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 43799	
Estimate Number : 10333	
P.O. Number :	Part Number : D2530
This Issue : 27/11/2008 S.O. No. :	Drawing Number : D2530 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 27/11/2008 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 40758	Material :
Written By :	Due Date : 20/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>SAD 08.11.27</u>	
Comment : Est Rev:E Removed Purchasing 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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✓
Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s)
 Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)
 Batch: M109314

SAD 08-12-18 20

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

SAD 08-12-18 21

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SAD 08/12/18 counter (X22)

4.0	D2534	Lock Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	18X B40212 24X B43843

EL 8-12-23 (X22)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

M107051

EL 8-12-31 (X22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 43799

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Deburr

6.0

QC9

VISUAL WELDING INSPECTION



Cpl 09-01-06



(21)

Comment: VISUAL WELDING INSPECTION

7.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (21)

8.0

POWDER COATING

POWDER COATING



m105642



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

7:20

OVEN TEMPERATURE:

320°

FINISH TIME:

7:50

FL 09/01/09

(21)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 09/01/09

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 204

88

09/01/09 (21)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12

Comment: FINAL INSPECTION/W/O RELEASE

MF 09-01-09

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



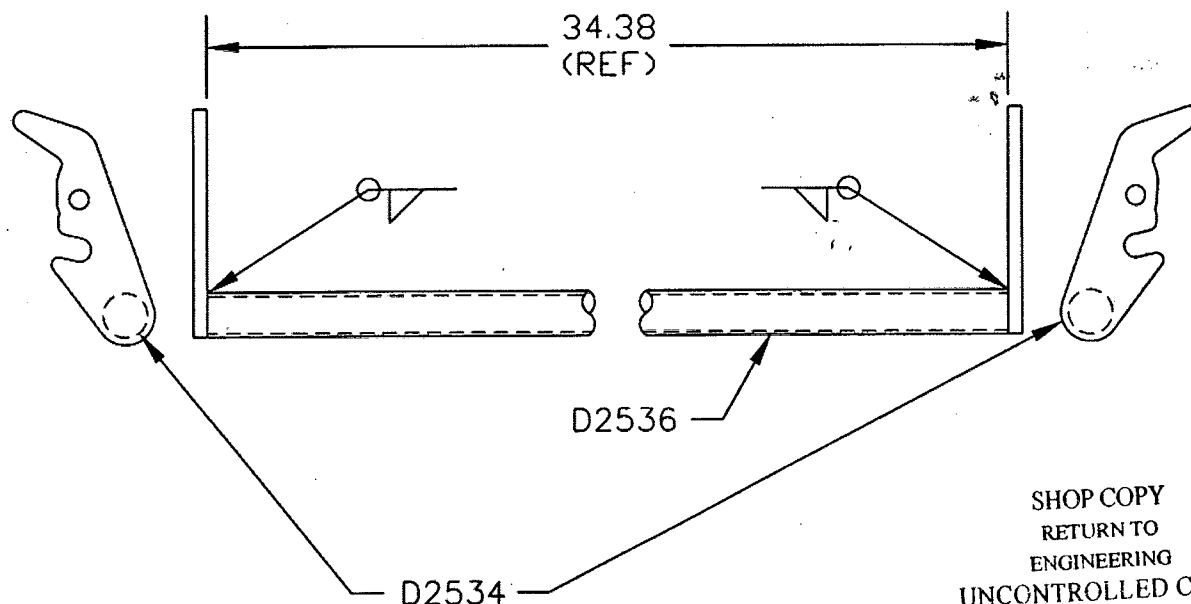
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2530	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43799

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

